

Date: Wednesday, 4/19/2006 8:14:41 AM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: DOUBLER
<b>Job Number</b>	: 26723		
<b>Estimate Number</b>	: 11471		
<b>P.O. Number</b>	: N/A	<b>Part Number</b>	: D3140101
<b>This Issue</b>	: 4/19/2006	<b>Drawing Number</b>	: D3140 REV D1
<b>Prsht Rev.</b>	: NC	<b>Project Number</b>	: N/A
<b>First Issue</b>	: N/A	<b>Drawing Revision</b>	: D1
<b>Previous Run</b>	: N/A	<b>Material</b>	: N/A
<b>Written By</b>	: See <u>1A</u> comment below	<b>Due Date</b>	: 4/26/2006
<b>Checked &amp; Approved By</b>	: <u>JF 06.04.19</u>	<b>Qty:</b>	4
<b>Comment</b>	: Est. A 02.04.30 New Issue NG Est. B 06.04.18 New dwg rev. ecn781 EC	<b>Um:</b>	Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S032	2024-T3 .032 sheet
		<b>Comment:</b> Qty.: 0.0466 sf(s)/Unit Total : 0.1865 sf(s) 2024-T3 .032 sheet Matl: 2024-T3 ( QQ-A-250/4 ) .032" thick ( M2024T3S.032 ) 2.20" x 2.80" ref Note: Part not square. Batch <u>M12758</u>
2.0	SHEAR	SHEAR
		<b>Comment:</b> SHEAR Cut as per dwg D3140 Deburr. No sharp edges <i>Hand made</i> <u>ml06/04/19</u>
3.0	QC5	INSPECT WORK TO CURRENT STEP
		<b>Comment:</b> INSPECT WORK TO CURRENT STEP <u>ml06/04/20</u> ④
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		<b>Comment:</b> HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 <u>DL 06/04/20</u> ⑤
5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		<b>Comment:</b> INSPECT POWDER COAT/CHEMICAL CONVERSION <u>C 206/04/20</u> ⑥

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/04/21  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/19/2006 8:14:41 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 26723

Part Number: D3140101

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	PACKAGING 1	PACKAGING RESOURCE #1
	<p>Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>✓</u></p> <p><i>C Loc 04/20 ④</i></p>	
7.0	DC	DOCUMENT CONTROL
	<p>Comment: DOCUMENT CONTROL Inspection Level 21</p> <p><i>Loc 04/21 ④</i></p>	

Job Completion



*U 04/21*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3140	REV. D SHEET 1 OF 7
DATE 05.11.23		TITLE DOOR	SCALE NTS
A	02.04.18	NEW ISSUE	
B	03.01.23	REMOVE -65/-81/-83; ADD -301/-303	
C	04.11.08	CHANGE DELASTEK SPEC. TEC-77; ADD PART MARKING; ADD NOTES 11, 12, 13; CHANGE ANGLE -95/-97/-98 TO 106°	
D	05.11.23	ADD -103/-104/-105/-106; REMOVE -67	
DI	<i>[Signature] 06.03.31</i>	1.75 WAS 1.83 ; 4.75 WAS 4.13	

QTY -05	QTY -06	QTY -07	QTY -08	QTY -09	QTY -10	PART NUMBER	DESCRIPTION
X						D3140-05	DOOR
	X					D3140-06	DOOR
		X				D3140-07	DOOR
			X			D3140-08	DOOR
		1		X		D3140-09	DOUBLER ASSEMBLY
				1	X	D3140-10	DOUBLER ASSEMBLY
3	3					D3140-57	PAD
1	1					D3140-59	PAD
2	2					D3140-61	PAD
2	2					D3140-63	PAD
		1	1			D3140-69	PAD
		1	1			D3140-71	PAD
		1	1			D3140-73	PAD
		1	1			D3140-75	PAD
		1	1			D3140-77	PAD
		1	1			D3140-79	PAD
				1	1	D3140-85	ANGLE
1	1					D3140-87	DOUBLER
				1	1	D3140-89	DOUBLER
		1				D3140-91	DOUBLER
			1			D3140-92	DOUBLER
3	3					D3140-95	DOUBLER
1						D3140-97	DOUBLER
1						D3140-98	DOUBLER
		1	1			D3140-99	DOUBLER
		2	2			D3140-101	DOUBLER
		1				D3140-103	DOUBLER
			1			D3140-104	DOUBLER
			1			D3140-105	DOUBLER
				1		D3140-106	DOUBLER
1	1					D3140-241	DOUBLER
1		1				D3140-301	DOUBLER
		1	1			D3140-303	DOUBLER
				5	5	MS20426AD3-4	RIVET
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DATE 05.11.23		TITLE DOOR	SCALE NTS



COMPOSITE LAYUP & BONDING I.A.W. DELASTEK PROCESS SPEC. TEC-77  
MATERIAL STORAGE & HANDLING TO BE I.A.W. DART QSI 006  
MAIN LAYUP USES FIBERCOTE E-761/7781 EPOXY FIBERGLASS.  
FILL WITH EPOCAST 87269 OR MAGNOBOND 77 A & B AND MA560 FOAM/ NB-51/30 FOAM



FINISH: DUPONT HIGHBUILD GREY PRIMER 1144-S



MAKE PARTS IN ACCORDANCE WITH THE FOLLOWING TOOLS/MOLDS:

PART	TOOL
D3140-05	B30-23000-01T
D3140-06	B30-23000-02T
D3140-07	B30-23000-03T
D3140-08	B30-23000-04T
D3140-57	B30-23000-57T
D3140-61	B30-23000-61T
D3140-63	B30-23000-63T
D3140-69	B30-23000-69T
D3140-71	B30-23000-71T
D3140-73	B30-23000-73T
D3140-75	B30-23000-75T
D3140-77	B30-23000-77T
D3140-79	B30-23000-79T
D3140-89	D3140-89T1
D3140-301	D3140-301T1
D3140-303	D3140-303T1

**RELEASED**  
05.12.01 *[Signature]*



MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



MATERIAL: 2024-T3 (QQ-A-250/4) 0.020 THICK (M2024T3S.020)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.040 THICK (M5052H32S.040)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



MATERIAL: POLIMEX TR75 1" THICK 4.5 LB KLEGECCELL



ALL DIMENSIONS IN INCHES



TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (M6061-T6S.063)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



DOUBLER TO SIT ON TOP OF FOAM AT THIS LOCATION



DOUBLER TO BE RECESSED FLUSH INTO FOAM AT THIS LOCATION

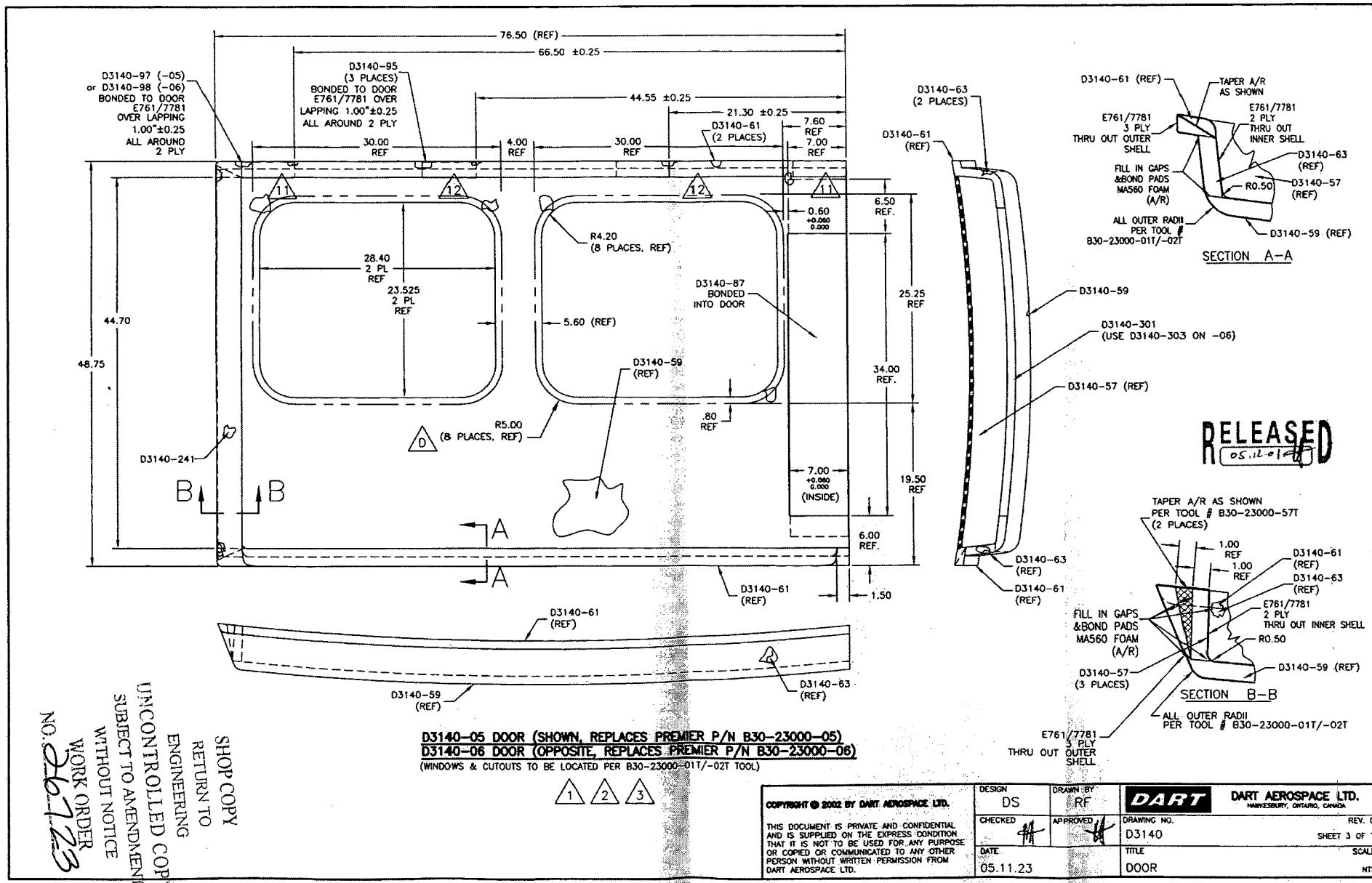


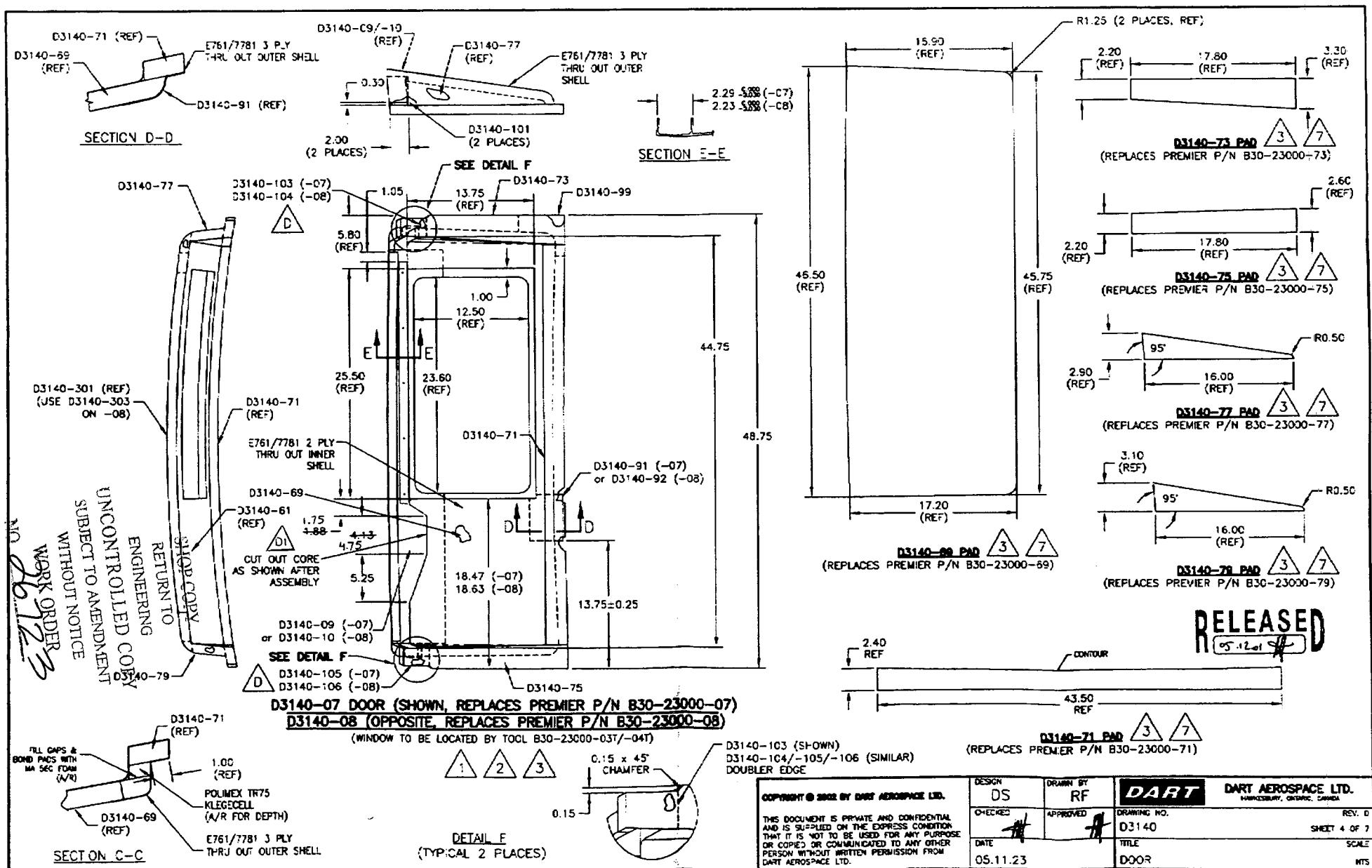
RUBBER STAMP WITH DART P/N D3140-05/-06/-07/-08 USING MIL-STD-130

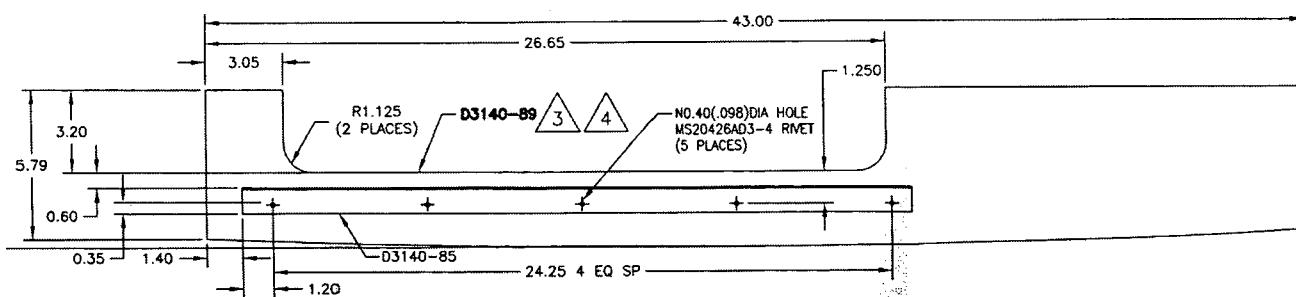
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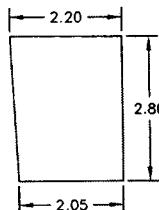
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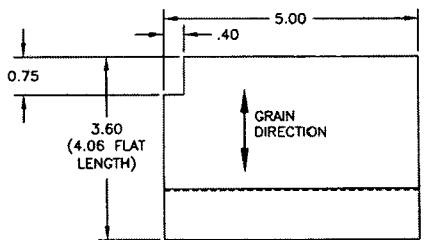




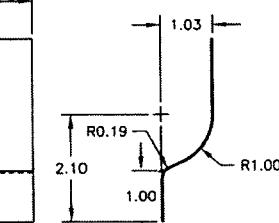
**D3140-10 DOUBLER ASSEMBLY (SHOWN, REPLACES PREMIER P/N B30-23000-10)**  
**D3140-09 DOUBLER ASSEMBLY (OPPOSITE, REPLACES PREMIER P/N B30-23000-09)**



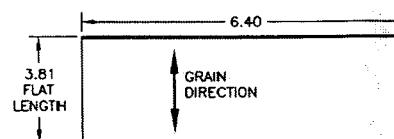
**D3140-101 DOUBLER** 4  
 (REPLACES PREMIER P/N B30-23000-101)



**D3140-91F FLAT PATTERN**  
 (USE TO MAKE D3140-91/-92 DOBLERS)

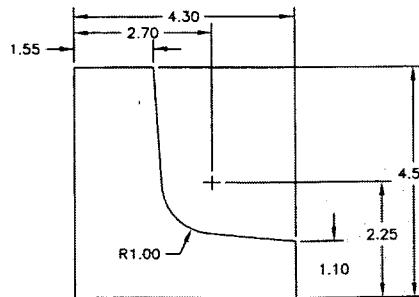


**D3140-91 DOUBLER** 4  
 (SHOWN, REPLACES PREMIER P/N B30-23000-91)  
**D3140-92 DOUBLER**  
 (OPPOSITE, REPLACES PREMIER P/N B30-23000-92)

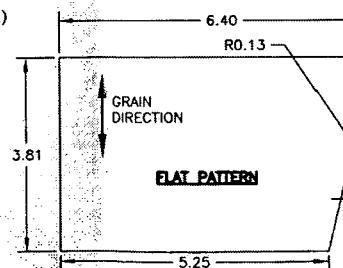


**D3140-95 DOUBLER** 4  
 (REPLACES PREMIER P/N B30-23000-95)

RELEASED  
 05/10/01



**D3140-99 DOUBLER** 4  
 (REPLACES PREMIER P/N B30-23000-99)



**D3140-97F FLAT PATTERN**  
 (USE TO MAKE D3140-97/-98 DOBLERS)



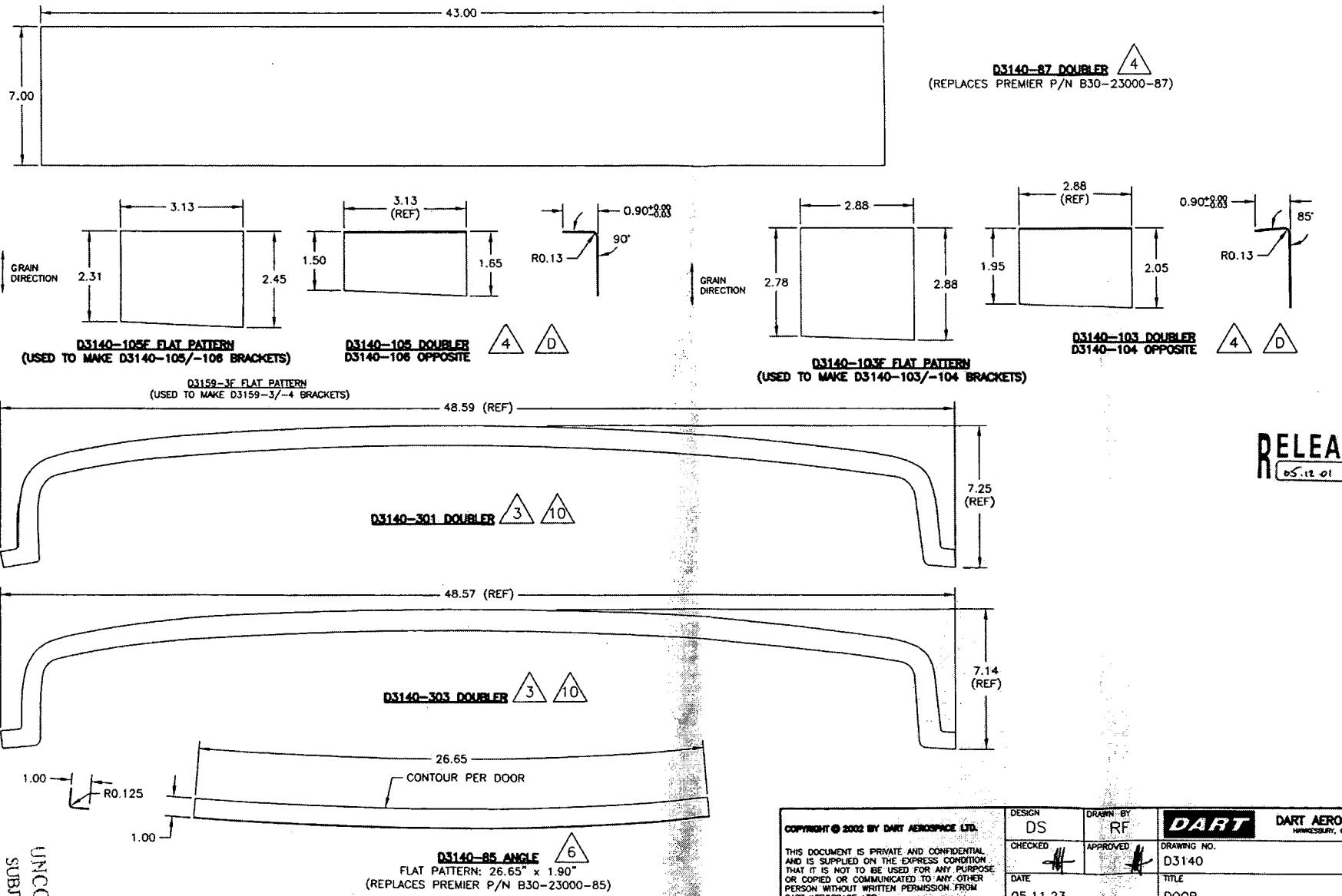
**D3140-97 DOUBLER** 4  
 (SHOWN, REPLACES PREMIER P/N B30-23000-97)  
**D3140-98 DOUBLER**  
 (OPPOSITE, REPLACES PREMIER P/N B30-23000-98)

BEND DETAIL

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DS	RF		HAMILTON, ONTARIO, CANADA
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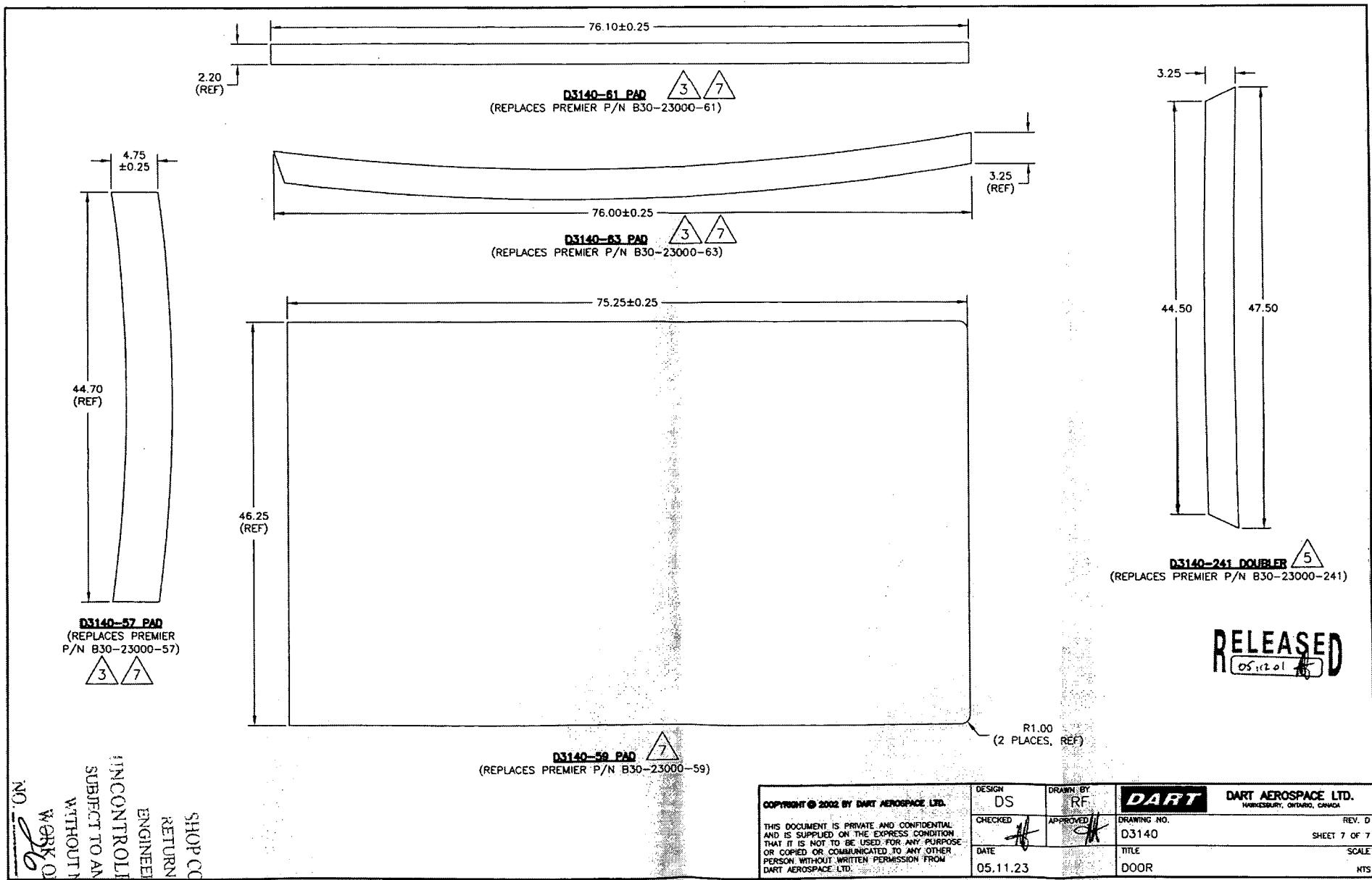
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